

ASAP PleaseDate: Wednesday, 06/12/2006 7:40:34 AM
User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: PACKER
Job Number	: 29837		
Estimate Number	: 10225		
P.O. Number	: N/A	Part Number	: D2150
This Issue	: 06/12/2006 S.O. No. : N/A	Drawing Number	: D2150 REV. A
Prsh Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: A
Previous Run	: 28279	Material	: N/A
Written By	:	Due Date	: 13/12/2006 Qty: 40 Um: Each
Checked & Approved By	:		
Comment	: Est C 00.11.27 Re-format (mpp 2101) EC Est Rev:D 06-08-23 Now on Waterjet	JLM	

Additional Product

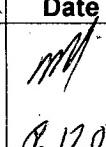
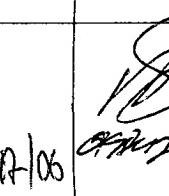
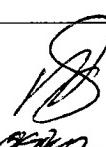
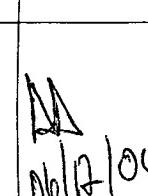
Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S040	2024-T3 .040 sheet	 <i>ML 06 12 07 (40)</i>
		Comment: Qty.: 0.0263 sf(s)/Unit Total : 1.0500 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch: <u>M102448</u>	<i>ML 06 12 07 (40)</i>
2.0	WATER JET	FLOW WATER JET	 <i>ML 06 12 07 (40)</i>
		Comment: FLOW WATER JET 1-Cut as per Dwg D2150 Dwg Rev: <u>A</u> <i>ML 06 12 06</i> Prog Rev: <u>A</u>	<i>ML 06 12 06 (40)</i>
		2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	 <i>ML 06 12 07 (40)</i>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>ML 06 12 06 (40)</i>
4.0	QC8	SECOND CHECK	 <i>ML 06 12 07 (40)</i>
		Comment: SECOND CHECK	<i>ML 06 12 07 (40)</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	 <i>ML 06 12 07 (40)</i>
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr	<i>SAN 06 12 07 (40)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/12/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action - Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/12/06	9	DXF was wrong	 <u>ASPERZ</u>	Scrap & replace	 <u>ASPERZ</u> 06/12/06	 <u>ASPERZ</u> 06/12/06	 <u>ASPERZ</u> 06/12/06	 <u>ASPERZ</u> 06/12/06

NOTE: Date & initial all entries

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Process Sheet

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Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FC 06 12 15

(40)

7.0 POWDER COATING POWDER COATING



M 102391



(40)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-k/a.m 06/12/15

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



QC3/12/15



(40)

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



PACKAGING 1/12/15



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: S726

QC3/12/15 40

(40)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

QC3/12/18

Job Completion



U 06.12.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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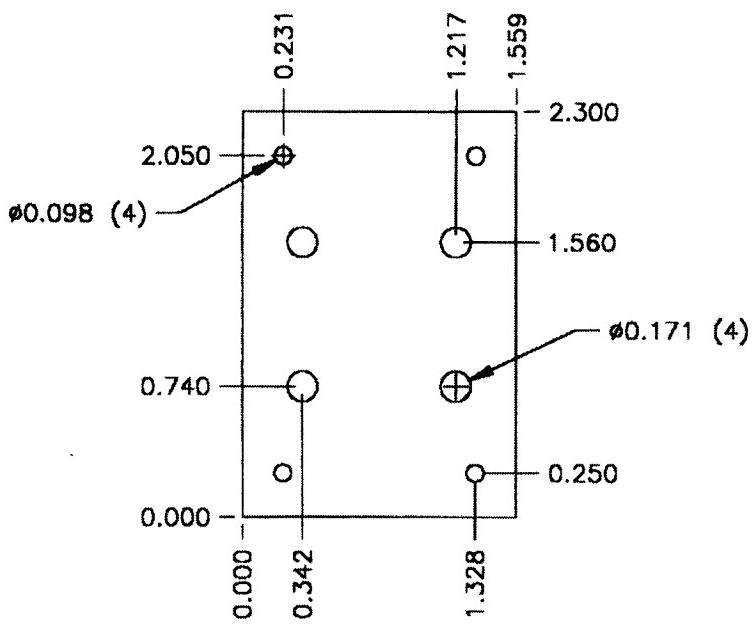
NOTE: Date & initial all entries



BY COPY IS
ISSUED

DESIGN B. WILLIAMS	DRAWN BY K. HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>B.L.</i>	APPROVED <i>B.L.</i>	DRAWING NO. D2150
DATE 95:05:01	TITLE PACKER	REV. A SHEET 1 OF 1 SCALE 1:1

RELEASED
16/06/93 BQ



W/O 29832
u
① b. (200)

MATERIAL: 2024-T3, 0.040 THICK
FINISH: WHITE POWDER COAT HI-GLOSS

DART AEROSPACE LTD

Work Order: 29831

Description: Packer

Part Number: D2150

Inspection Dwg: D2150 Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by: *[Signature]*

Audited by:

Prototype Approval:

Date: 08/17/07

Date: 8/12/07

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	